

In the claims:

Please amend the claims as follows:

Claims 1-20 (cancelled)

Claim 21 (currently amended): A method of cleaning a circumferential surface of a roll rotating upon a rotational axis comprising the steps of:

- a) positioning a doctor blade having a long axis near the roll surface such that the long axis of the doctor blade is substantially parallel with the rotational axis of the roll, the doctor blade comprising a plurality of unidirectional fibers impregnated with a resin, wherein the unidirectional fibers are provided in a unidirectional fabric that includes, based on fabric weight, at least 60% by weight unidirectional fibers; and
- b) pressing a beveled edge of the doctor blade against the surface of the roll.

Claim 22 (currently amended): A method of decreasing the roughness of a circumferential surface of a roll rotating upon a rotational axis comprising the steps of:

- a) positioning a doctor blade having a long axis near the roll surface such that the long axis of the doctor blade is substantially parallel with the rotational axis of the roll, the doctor blade comprising a plurality of unidirectional fibers impregnated with a resin, wherein the unidirectional fibers are provided in a unidirectional fabric that includes, based on fabric weight, at least 60% by weight unidirectional fibers; and
- b) pressing a beveled edge of the doctor blade against the surface of the roll.

Claim 23 (original): A method of claim 21 or 22 wherein the beveled edge of the doctor blade remains in substantially continuous contact with the surface of the roll during operation.

Claim 24 (original): A method of claim 21 or 22 wherein the positioning step includes positioning the doctor blade at an operating angle of about 25 to 30°.

Claim 25 (original): A method of claim 21 or 22 wherein the pressing step is performed at a pressure of about 85 to 700 N/m.

Claim 26 (original): A method of claim 25 wherein the pressing step is performed at a pressure of about 175 to 440 N/m.

Claim 27 (original): A method of claim 22 wherein the roughness of the surface of the roll is decreased to about 0.025 to 0.20  $\mu\text{m Ra}$ .

Claim 28 (original): A method of claim 27 wherein the roughness of the surface of the roll is decreased to about 0.05 to 0.13  $\mu\text{m Ra}$ .

Claim 29 (original): A method of claim 22 wherein the roughness of the surface of the roll is maintained during the effective life of the doctor blade at a level of about 0.025 to 0.20  $\mu\text{m Ra}$ .

Claim 30 (original): A method of claim 29 wherein the roughness of the surface of the roll is maintained at a level of 0.05 to 0.13  $\mu\text{m Ra}$ .

Claim 31 (currently amended): A method of making a composite doctor blade comprising impregnating a composite material comprising unidirectional fibers with a resin, wherein the unidirectional fibers are provided in a unidirectional fabric that includes, based on fabric weight, at least 60% by weight unidirectional fibers.

Claim 32 (original): A method of claim 31 further comprising superimposing multiple layers of composite material on top of one another to form a laminate structure.

Claim 33 (original): A method of claim 31 or 32 further comprising curing the resin by subjecting the impregnated composite material to an elevated temperature and pressure.

Claim 34 (original): A method of claim 33 further comprising cutting the cured composite material into 2 or more doctor blades.

Claim 35 (currently amended): The method of claim 21, 22 or 31 wherein the unidirectional fibers are selected from the group consisting of fiberglass, ceramic, and mixtures thereof.

Claim 36 (original): The method of claim 35 wherein the unidirectional fibers comprise fiberglass.

Claim 37 (currently amended): The method of claim ~~34~~ 35 wherein the unidirectional fibers comprise ~~predominantly~~ long continuous fibers.

Claim 38 (cancelled)

Claim 39 (currently amended): The method of claim 21, 22 or 31 ~~38~~ wherein at least 75% by weight of the unidirectional fabric comprises unidirectional fibers.

Claim 40 (original): The method of claim 39 wherein at least 90% by weight of the unidirectional fabric comprises unidirectional fibers.

Claim 41 (new): The method of claim 21, 22 or 31 wherein the unidirectional fabric further comprises secondary fibers.

Claim 42 (new): The method of claim 41 wherein the unidirectional fibers have diameters equal to or greater than the diameters of the secondary fibers.

Claim 43 (new): The method of claim 42 wherein the diameters of the unidirectional fibers are about 450 to 1500  $\mu\text{m}$  and the diameters of the secondary fibers are about 400 to 700  $\mu\text{m}$ .

Claim 44 (new): The method of claim 21, 22 or 31 wherein the unidirectional fabric further comprises nonabrasive fibers.

Claim 45 (new): The method of claim 44 wherein the nonabrasive fibers are selected from the group consisting of carbon, rayon, aramid, polyester, and mixtures thereof.

Claim 46 (new): The method of claim 45 wherein the nonabrasive fibers comprise carbon fibers aligned in a direction substantially perpendicular to the long axis of the doctor blade.

Claim 47 (new): The method of claim 21, 22 or 31 wherein the unidirectional fabric has a weight per unit area of about 230 to 610 g/m<sup>2</sup>.

Claim 48 (new): The method of claim 21, 22 or 31 wherein the resin comprises a thermoplastic resin.

Claim 49 (new): The method of claim 48 wherein the resin comprises an epoxy resin.

Claim 50 (new): The method of claim 49 wherein the resin has a glass transition temperature of about 65 to 315 °C.

Claim 51 (new): The method of claim 50 wherein the resin has a glass transition temperature of about 85 to 315 °C.

Claim 52 (new): The method of claim 48 wherein the resin further comprises an abrasive additive selected from the group consisting of glass microspheres, glass fibers, crushed glass, synthetic or industrial diamond particles, silica particles, silicon carbide particles, boron particles, zirconium particles, aluminum oxide particles and mixtures thereof.